

26

Date: Thursday, 5/31/2007 7:22:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP LH (FOLDING)
 Job Number : 32715
 Estimate Number : 12567
 P.O. Number : N/A Part Number : D412630033
 This Issue : 5/31/2007 S.O. No. : N/A Drawing Number : IIN D412-630 REV K
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : K
 Previous Run : 32713 Material : N/A
 Due Date : 6/30/2007 Qty: 5 Um: Each
 Written By :
 Checked & Approved By : 07.05.31
 Comment : Est. Rev A New Issue 06-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG002

K-S 07-06-05

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

1529883

38554

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

B-27119 15 29391

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

27561, 7/2/11SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

101
13284881
27562

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

1329396

7.0

D3562041

STEP ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-041	Step Weldment LH

Batch

1332919

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

1328455

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

(4) * 1101189
1100695 7/7/1150

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Seq. #:

Machine Or Operation:

Description:

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

4
M100695, M102736

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

(4)
M100433, M102728

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M100998

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

8
M104679
M100580, 2/2/11SP

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

(4)

M101331, M102067

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M104679

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390, 7/7/11 SP

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M17045

MF

07-07-18

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/07/19 (45)

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

29393 ✓

59

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

29394 ✓

59

3

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

29395 ✓

59

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

29496 ✓

59

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

7/3/23 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

M101273 ✓ S9

M101189 ✓

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

M102959 ✓ S9

28.0

AN4C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C7A	Eyebolt

Batch

M101711 ✓ S9

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

M101291 ✓ S9

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H4	Washer

Batch

M101428 ✓ 7/7/23 S9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

3
M104885

M105057

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M104936

54

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

10
M10418, M104729, 7/7/23 54 (5)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: A

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.07.23

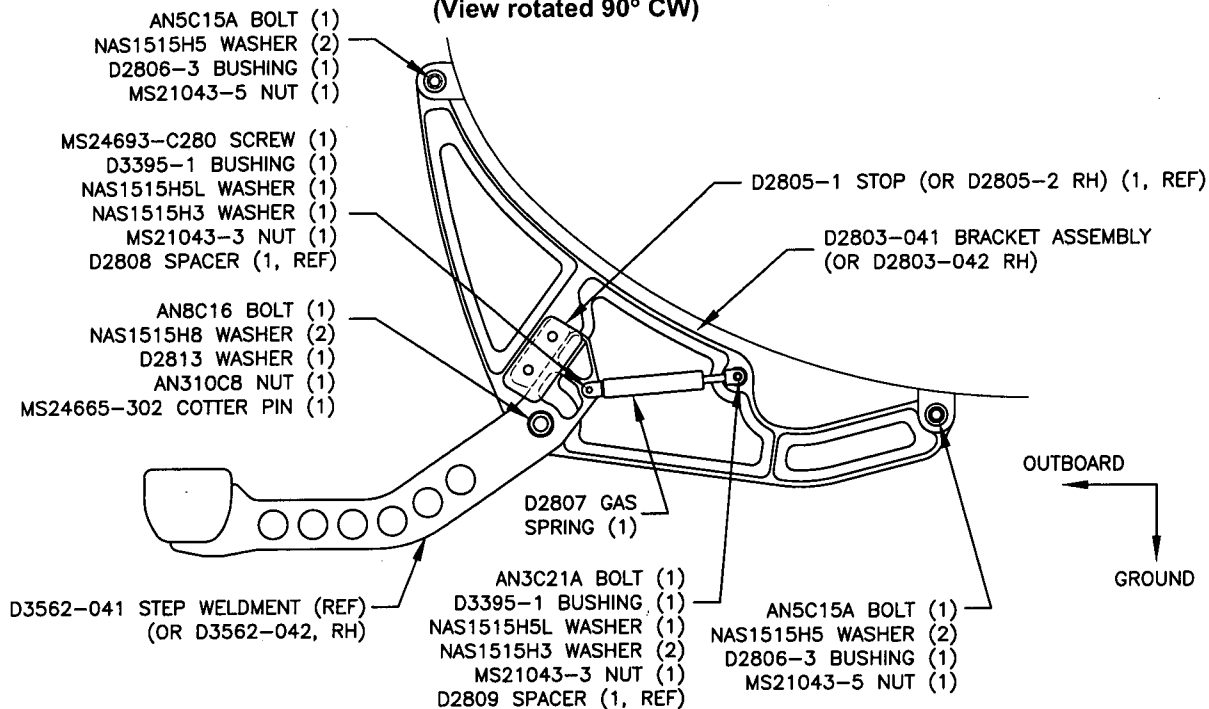
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)